



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2731-3
Job Sheet 204336



Part No: D2731-3

Job Qty: 48 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/19

Job Tracking No:

Due Date: 1/17/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP: D 00.05.19 Added inspect level 8, removed P/O for powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	48 pcs		1/17/20	0.00	0.00	Purchasing - 1		DEC 17 2019
							Purchasing - 2		
							Purchasing - 3		
120	Packaging 2-1 - Receive - B4B	48 pcs		1/17/20	0.00	0.00	Packaging 2 - 1 - B4B		DEC 17 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S241464



Part: D2731-3

Job No: 204336

Serial No/Batch: S241464

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/17/19

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130	QC 6	48 pcs	1/17/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
140	Handfinish - 1-1 Chemical- B4B	48 pcs	1/17/20	0.00 1.60	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	48 pcs	1/17/20	0.00 1.92	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	48	1/17/20	0.00 0.00	QC 3 - 10	

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N/R

N/R

N/R

pcs

					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	48	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ST-520
					Packaging 3 - 5 - B4B	DAS 74 JAN 17 2020
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
					Packaging 3 - 36 - B4B	21
180	QC 21 - SA	48	1/17/20	0.00 0.00	QC 21 - SA - 21	9-89 JAN 17 2020

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 110 - (Purchasing) Outsource process - Machining Issue P/O to Metec : #B045352 Machine as per dwg C of C
 Descriptions: is required

120 - Receive & Inspect for Damage & Mat'l Certs ENSURE C OF C IS ATTACH.

130 - QC6- All purchased or subcontracted products

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

x48 *du hus*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.2784 ft (.0683 ea)	110-Purchasing	<u>S175797</u>
D2731-3P	Lug	48 pcs (1 ea)	110-Purchasing	<u>S241443</u>

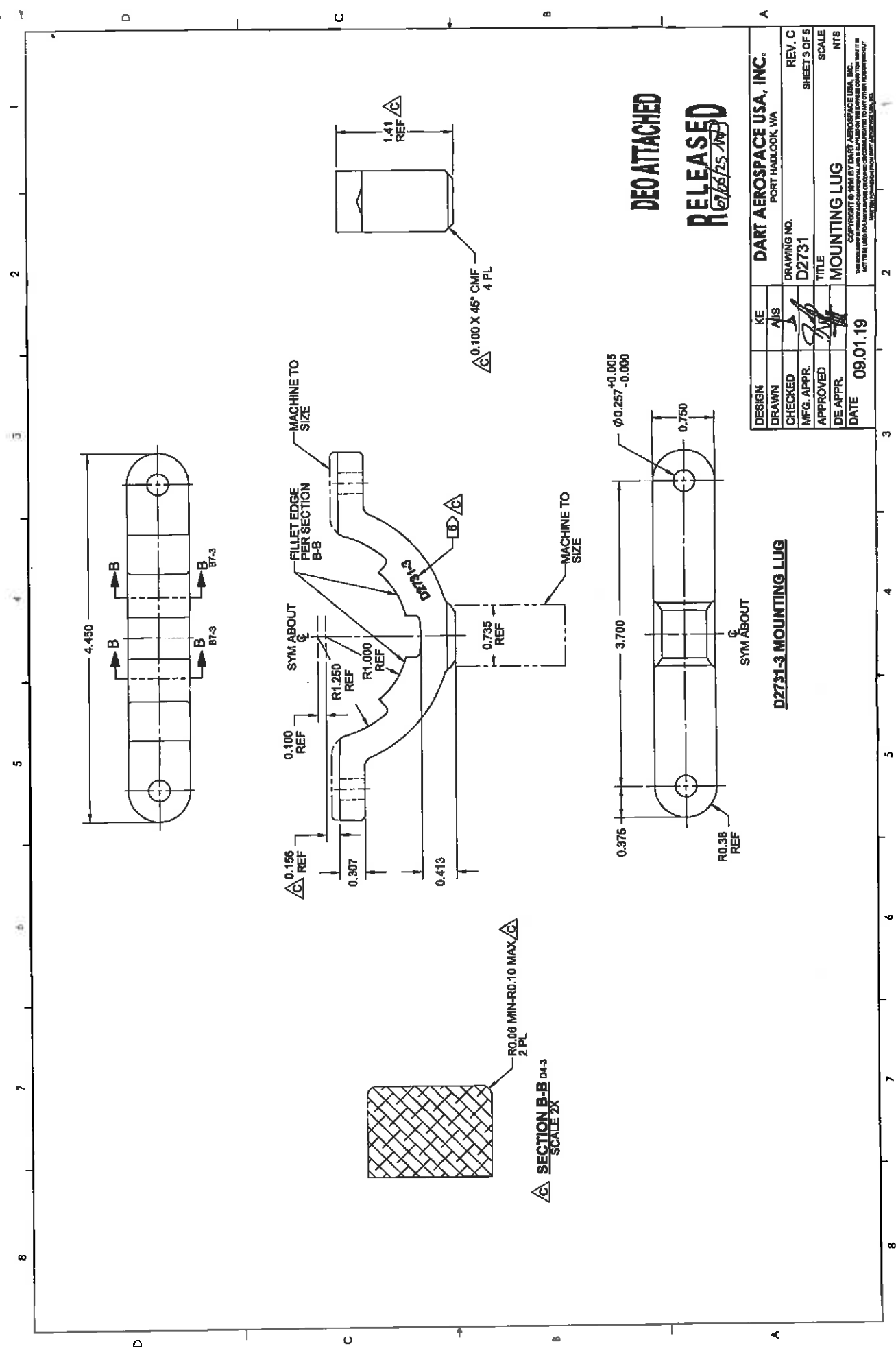
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	321	0
	D2731-3P	48	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches ± 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches ± 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches ± 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches ± 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches ± 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
7	Mounting Lug	0.750Inches ± 0.010	0.760 0.740		
8	Mounting Lug	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Mounting Lug	0.100Inches ± 0.010	0.110 0.090		
10	Mounting Lug	45.000Degrees ± 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	

Plex 12/6/19 11:46 AM Dart.Renwick.Jennifer



DEO ATTACHED
RELEASED
02/05/75 JND

DESIGN	KE	DART AEROSPACE USA, INC.
DRAWN	AUS	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2731
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE MOUNTING LUG
DE APPR.		SCALE NTS
DATE	09.01.19	

D2731-3 MOUNTING LUG

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045352



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045352
PO Date: 12/9/19
Due Date: 1/17/20
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204336	D2731-3P	D2731 Rev.C			Lug As Per Dwg D2731 Rev.C	Firmed	-	1/17/20	48 pcs	0 pcs	48 pcs	\$16.20/pcs	\$777.60
													Grand Total:	\$777.60

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9-89

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 12/9/19 2:32 PM dart.lussier.patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 26284
Shipment Date: 09-Dec-2019
Ship Via: Pick up at METEC
Order Number: 4460
Order Date: 12/09/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB045352
Terms: Net 60 Days

Quantity								
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
1	48	48	0	0	EA	DART-D2731-3P Mounting Lug alodined and painted as per QSI005	C	4460-01

RECEIVED

DEC 17 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.



Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
48	D2731-3	Mounting Lug	C	S175797	128686-1	HB045352

MATERIAL: supplied by DART

DAS
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9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, December 10, 2019

DART LUGS JOBSHEET



DATE: May 18/2017	MATERIAL BATCH #: 5175797
PART NAME: Lug	MATERIAL: EXTRUSION D2423
DWG #: D2731-3 REV. C	MACHINE: HAAS
QUANTITY TO MAKE: 120 pcs.	we have 80 painted in stock

MACHINING Setups: 20min				
DATE STARTED	DATE FINISHED	EMPLOYEE	RUNTIME	QUANTITY MADE
06-20-17	06-20-17	Jeff	6 1/2 min	7
06/20/17	06/20/17	Amy	" "	56
06-20-17	06-20-17	2/H	"	16
06-21-17	06-21-17	2/H + Amy	"	48
			148835	QTY SCRAPPED - 7
				TOTAL QTY READY 120 - 24 = 96

FOR PAINTING TO ALTECH				DART		
QTY SENT TO ALTECH	DATE SENT	METEC PO #	DATE RECEIVED BACK	DART PO #	QTY ORDERED	DATE DELIVERED TO DART
		not painted		36351	24	June 20/17
96	July 4/17	21115	July 18/17			
				H8045352	48	Dec 10/19

Total CNC Hrs	
Total Manual Hrs	
Finishing	
Sub	
Freight	
TOTAL COST	
COST EACH	PRICE QUOTED



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.:(514)335-3666 Fax.:(514)335-3868
Internet : www.groupealtech.com

Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance

Bon-Livraison / Pk.Slip # : 128686-1 17/07/2017
Bon-Commande. / W.Order # : 128686
Client P.O. # : 21115
Transport :

Envoyé à / Ship to

METEC
20 TERRY FOX DRIVE, P.O. BOX 7
VANKLEEK HILL
ONTARIO, CANADA K0B 1R0

Commandé par / Order by

METEC (0285)
20 TERRY FOX DRIVE, P.O. BOX 7
VANKLEEK HILL
ONTARIO, CANADA K0B 1R0

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	DART 2731-3 Rev. MOUNTING LUG	ALODINE 1200S AND PAINT POWDER WHITE AS PER QSI005	0.00	96	96	0
2	UNIT	DART 2230-3 Rev. MOUNTING LUG	ALODINE 1200S AND PAINT POWDER WHITE AS PER QSI005	0.00	58	58	0

OK P
July 18/17
Rec'd SA
Dart

\$ 300.30

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Attestons que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

DART AEROSPACE LTD FIRST ARTICLE INSPECTION CHECKLIST

Work Order:

D2731-3

Inspection Dwg: D2731

Rev: C

Description: Lug

Part Number:

D2731-3

Inspection Dwg: D2731

Office:

Part Number:

D2731-3

Inspection Dwg: D2731

ORDERED: 20

Part Number:

D2731-3

Inspection Dwg: D2731

TO INSPECT: 13

Part Number:

D2731-3

Inspection Dwg: D2731

Material Batch#

Part Number:

D2731-3

Inspection Dwg: D2731

Drawing Dimension	Tolerance	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O	Actual Dimension	O
4.450	4.440-4.460	4.454		4.454		4.455		4.454		4.454		4.454		4.455		4.454	
0.307	0.297-0.317	0.306		0.306		0.306		0.305		0.305		0.304		0.304		0.304	
0.413	0.403-0.423	0.409		0.409		0.408		0.408		0.408		0.408		0.408		0.408	
3.700	3.695-3.710	3.700		3.700		3.699		3.700		3.700		3.700		3.700		3.700	
0.750	0.740-0.760	0.755		0.753		0.753		0.753		0.753		0.753		0.753		0.753	
0.257	0.257-0.262	0.259		0.259		0.259		0.259		0.259		0.259		0.259		0.259	
1.41	1.38-1.44	1.416		1.416		1.416		1.416		1.416		1.416		1.416		1.416	
R1.000	0.990-1.010			0.377		0.375		0.373		0.374		0.374		0.375		0.375	
0.375	0.365-0.385	0.376															
0.100 x 45°	0.090-0.110																
Check existence of radii Section B-B																	
Engraving Depth 0.010+-0.005																	
Tool Tip Radius 0.015+-0.005																	
Edges, Corners & Holes De-Burred																	
INSPECTED BY: JH																	
DATE: 06/20/17																	
4.450	4.440-4.460	4.453		4.453		4.455		4.454		4.455		4.454		4.454		4.454	
0.307	0.297-0.317	0.303		0.303		0.305		0.306		0.304		0.306		0.306		0.306	
0.413	0.403-0.423	0.408		0.408		0.412		0.414		0.415		0.414		0.414		0.414	
3.700	3.695-3.710	3.700		3.700		3.698		3.699		3.700		3.700		3.700		3.700	
0.750	0.740-0.760	0.754		0.754		0.754		0.753		0.753		0.753		0.753		0.753	
0.257	0.257-0.262	0.258		0.258		0.258		0.258		0.258		0.258		0.258		0.258	
1.41	1.38-1.44	1.420		1.420		1.420		1.421		1.420		1.421		1.421		1.421	
R1.000	0.990-1.010							0.372		0.373		0.373		0.374		0.375	
0.375	0.365-0.385	0.375		0.374		0.376											
0.100 x 45°	0.090-0.110																
Check existence of radii Section B-B																	
Engraving Depth 0.010+-0.005																	
Tool Tip Radius 0.015+-0.005																	
Edges, Corners & Holes De-Burred																	
INSPECTED BY: JH																	
DATE: 06/20/17																	

Method of Inspection:

NOTES:

Vernier calipers, Radius gauge, Visual and tactile inspection for burrs.

LOT SIZE: SAMPLE SIZE

2 to 13: All 14 to 150: 13 151 to 280: 20

to 500: 29 501 to 1200: 34